

DEPARTMENT OF COMMERCE

BUREAU OF STANDARDS

George K. Burgess, Director

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UNITED STATES GOVERNMENT MASTER SPECIFICATION FOR
DRILL (UNBLEACHED)

FEDERAL SPECIFICATIONS BOARD SPECIFICATION No. 557

This specification was officially promulgated by the Federal Specifications Board on May 22, 1928, for the use of the departments and independent establishments of the Government in the purchase of drill (unbleached).

[The technical requirements of this specification shall become mandatory for all departments and independent establishments of the Government not later than August 22, 1928. They may be put into effect, however, at any earlier date after promulgation.]

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I. GENERAL SPECIFICATIONS

United States Government general specification for textile materials (methods of physical and chemical tests), Federal Specifications Board specification No. 345, in effect on date of invitation for bids, shall form a part of this specification wherever applicable.

II. TYPES AND GRADES

1. TYPES.—Drill shall be furnished in the following types, as specified in the invitation for bids:

Type	Commercial designation
A.....	2.50 66 by 56
B.....	2.85 72 by 48
C.....	3.00 66 by 44
D.....	3.25 66 by 40

2. **GRADE.**—The grade shall be that known commercially as first quality.

III. MATERIAL

The material shall be made of cotton, thoroughly cleaned, and free from waste. It shall be as free as practicable from avoidable imperfections of manufacture.

IV. GENERAL REQUIREMENTS

See Detail requirements, Section V.

V. DETAIL REQUIREMENTS

1. **FINISH.**—The material shall be unbleached.
2. **WEAVE.**—The weave shall be a 3-harness twill $\left(2 \frac{\text{---}}{1}\right)$.
3. **WIDTH.**—The width shall be 30 inches unless otherwise specified. A tolerance of plus one-half inch or minus three-eighths inch will be permitted.
4. **LENGTH OF BOLT OR ROLL.**—Any commercial length over 35 yards will be acceptable, unless otherwise specified.
5. **WEIGHT.**—The weight per square yard shall be as given in the table. A tolerance of minus $2\frac{1}{2}$ and plus 5 per cent will be permitted.
6. **THREAD COUNT.**—The threads per inch shall be as given in the table. A tolerance of minus 3 threads and any plus tolerance will be permitted.
7. **BREAKING STRENGTH.**—The breaking strength (grab method) shall be as given in the table, except that no rejections will be made if the combined strength of the warp and the filling shall equal the combined strength of these elements given in the table, provided neither element is more than 10 per cent under the requirements.

Table of requirements

Type	Nominal yards per pound	Weight per square yard	Thread count		Breaking strength (grab method)	
			W	F	W	F
		<i>Ounces</i>			<i>Pounds</i>	<i>Pounds</i>
A.....	2.50	7.7	66	56	114	80
B.....	2.85	6.7	72	48	100	68
C.....	3.00	6.4	66	44	110	44
D.....	3.25	5.9	66	40	100	40

VI. METHOD OF SAMPLING AND TESTS

1. **SAMPLING.**—Not less than one sample at least 1 yard long, by the width of the material, shall be taken from each 1,000 yards

or fraction thereof, except where the shipment is 10,000 yards or more in which case a sample from each one-tenth of the shipment shall be taken for test purposes.

2. TESTING.—Federal Specifications Board specification No. 345, general specification for textile materials (methods of physical and chemical tests), in effect on date of invitation for bids, shall apply, except that the tests on 1-yard samples for width and weight shall not be used alone as a basis for rejection, but if a dispute arises regarding weight, the weight in yards per pound shall be determined from the actual yardage and the actual weight of the entire bolt.

VII. PACKING AND MARKING OF SHIPMENTS

Shall be in accordance with the best commercial practice unless otherwise specified.

VIII. NOTES

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